



Bergamid™ PA6-MW30 GR002

Polyamide 6

Key Characteristics

Product Description	
Glass fiber and glass beads reinforced PA6 compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Bead\Glass Fiber, 30% Filler by Weight
Appearance	• Green
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.41	1.41	ASTM D792
Molding Shrinkage	0.20 to 0.60 %	0.20 to 0.60 %	ASTM D955
Ash Content	32.0 to 38.0 %	32.0 to 38.0 %	Internal Method
Moisture	0.19 %	0.19 %	Internal Method
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	16700 psi	115 MPa	ASTM D638
Flexural Modulus ³	943000 psi	6500 MPa	ASTM D790
Flexural Strength ³	26100 psi	180 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	1.5 ft-lb/in	80 J/m	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	356 °F	180 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	> 1.0E+12 ohms	> 1.0E+12 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.13 in (3.2 mm))	HB	HB	Internal Method

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 194 °F	80.0 to 90.0 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Processing (Melt) Temp	464 to 536 °F	240 to 280 °C
Mold Temperature	149 to 185 °F	65.0 to 85.0 °C

Injection Notes	
Injection Pressure: MED-HIGH	
Hold Pressure: MED-HIGH	
Screw Speed: MODERATE	
Back Pressure: LOW	

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Notes

¹ Typical values are not to be construed as specifications.

² 0.20 in/min (5.0 mm/min)

³ 0.051 in/min (1.3 mm/min)

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